o Number : 36811B timate Number : 10462  D. Number : 10462  D. Number : D32782 Drawing Number : D3278 REV. C sit Issue : 1/17/2008 S.O. No. : Drawing Number : D3278 REV. C sit Issue : // Type : SMALL /MED FAB Drawing Revision : C evious Run : 36119B  Material : Due Date : 1/24/2008 Qty: 42 Um: Ea titten By ecked & Approved By : Est:A 04.04.19 New issue KJ/JLM Est B 07.09.06 Rev C dwg EC Verified by: JLM  ditional Product		The Land Laboration of the Control o	4.0		
Stormer   CULDAR001 Dart Helicopters Services   Drawling Name   SUPPORT	30.50° U	2.1	Process Sheet	SPUIT	
Number         38811B           Imate Number         10462           A Wamber         10462           In Issue         1/172008           S.O. No. :         The project Number : D3278 REV. C           In Issue         1/1           Type         : SMALL MED FAB           Dawing Revision :         C           Drawing Revision :         C           Dawing Revision :         C           Description :         Secked 8 Approved By :           Est B         07/09/06         Rev C dwg EC         Verified by: JLM           ditional Product         Seq. # Machine Or Operation:         Description :           Seq. # Machine Or Operation:         Description :           Seq. # Machine Or Operation:         Description :           Material: 6061-167/E51 (GO-A-200/8) 1.00° trick         Material: 6061-167/E51 (GO-A-200/8) 1.00° trick           Material: 200° x 1.00° x 2.550 (long         Batch: YN 1.01° x 2.50° (long           3.0         HASSI           Comment: HAAS CNO VERTICAL MACHINING #1           1- Mactine as per Folio FA/O5 and Dwg DX78           2- Debut and Tumble Identify as Q3278-2           Comment: INSPECT PARTS AS THEY COME OFF MACHINE           50         COMMENT: SECOND CHECK					
Number   388118	ustomer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT	
Distribute   10462   Distribute   10462   Distribute   10472008   S.O. No.     Part Number   103278   EV. C   Project Number   103278   EV. C	ob Number	The state of the s			
Dumber   1,000   1,0					
Second   S		. 10402	Part Number	· D32782	
## Rev. : NG					
State   17   Type   SMALL MED FAB   Drawing Revision   C   Material   Due Date   1/24/2008   Cty   Estat   0.504.19   New/issue KJJLM   Est   B   07.09.06   Rev C   dag   EC   Verified by JLM   Est   B   07.09.06   Rev C   dag   EC   Verified by JLM   Cty   Description   Estat   0.504.19   Number:   Description   Description   Estat   0.504.19   Number   Description   Estat   0.504.19   Number   Description   Estat   0.504.19   Number   Description   Estat   0.505.176   Estat   0	is Issue			* Control of the cont	
Material   Due Date   1/24/2008   Clty:   Due Date   1/24/20	sht Rev.				
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Secked & Approved By   Set	evious Run	: 36119B	Material	:	29
Sec. #:   Machine or Operation:   Description:		١.٨		: 1/24/2008 Qty:	42 Um: Eac
Seq. #:   Machine or Operation:   Description:	A 4 C C C C C C C C C C C C C C C C C C	- dalaco mic	· · · · · · · · · · · · · · · · · · ·		
State	necked & Approv		<u> </u>		
Number:	mment				
Number:		Est B 07.09.06 Rev C	dwg EC Verified by: JLM	21	
Seq. #:   Machine Or Operation:   Description:	Iditional Product				
Seq. #:   Machine Or Operation:   Description:	b Number:				
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Comment: Qty.: 0.2454 (s)/Unit Total: 49.3962-1(s) 55-2.15 F  Material: 6061-67/651 (QQ-A-200/8) 1.00* thick (M6061T6B1.000x02.000) Batch: YN 10 7 1 2 9  C JoS/c 2 1/5 55-2.15  2.0 SHEAR SHEAR Cut blank: 2.00* x 1.00* x 2.598* long  3.0 HAAS CNC VERTICAL MACHINING #1  1- Mactine as per Folio FA405 and Dwg D3278 2- Debut and Tumble Identify as\D3278-2  4.0 CC2 INSPERT PARTS AS THEY COME OFF MACHINE  5.0 CC8 SECOND CHECK  Comment: SECOND CHECK  1.1 TSSUE To: SLESS CSOND CHECK  1.1 TSSUE To: SLESS CSOND CHECK	Seq. #:	Machine Or Operation:	Description :	0	
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2- Debur and Tumble Identify as D3278-2  INSPECT PARTS AS THEY COME OFF MACHINE  Comment: INSPECT PARTS AS THEY COME OFF MACHINE  5.0 QC8  SECOND CHECK  1.1 ISSUE 76: 5655 CX08/02/08 (2.35)	Comme	<b>\</b>			/ , .
Comment: INSPECT PARTS AS THEY COME OFF MACHINE  5.0 QC8 SECOND CHECK  1.1 Tesue 76: 4055 CS08/02/08 (2.55)		<ol> <li>Machine as per Folio FA405 and Dw</li> </ol>	rg D <b>3</b> 278		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE  5.0 QC8 SECOND CHECK  1.1 Tesue 76: 4055 CS08/02/08 (2.55)		\			
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CRIVE AND ENSPREN FINGRONSIT DAMPUL ENSM A COPY OF CENT ANTACHES (80)	6/0	603.			1
CRIVE AND ENSPRENT FINGERENT DAMPLE ENSM ACOPY OF CENT ATTACKED (80)		and the second second		12/2 145 /	20/2/20
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	CRIVILA	IND INSTRUCT PROPORT D	AMAGE KITSING A CO	by or coll stylen	0)

Thursday, 1/17/2008 3:23:52 PM Date: · . User: Kim Johnston **Process Sheet** Drawing Name: SUPPORT Customer: CU-DAR001 Dart Helicopters Services Part Number: D32782 Job Number: 36811B Job Number: Description: Seq. #: Machine Or Operation: HAND FINISHING RESOURCE #1 6.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 M 107005 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 QC3 Comment: INSPECT POWDER COAT 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 FINAL INSPECTION/W/O RELEASE 20180 Comment: FINAL INSPECTION/W/O RELEASE - 2008/3/18 Job Completion

DART AEROSPACE LTD	Work Order:	368113
Description: Support	Part Number:	D3278-2
Inspection Dwg: D3278 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

V	First Article	Prototypo
^	FIRST ARTICLE	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000					
0.359	+/-0.005					
0.609	+/-0.010					/
0.250	+/-0.010					
1.480	+/-0.005		=======================================			
R0.125	+/-0.010					
0.119	+0.005/-0.004					
2.439	+/-0.010					
1.980	+/-0.010					
R0.13	+/-0.030		/			
Ø0.257	+0.005/-0.000					
R0.375	+/-0.010					
0.875	+/-0.010					
0.500	+/-0.010			1		
R0.400	+/-0.010					
R1.00	+/-0.030		Ü	10		
1.720	+/-0.010					
R0.125	+/-0.010				6	
0.125	+/-0.010					

Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	N/A

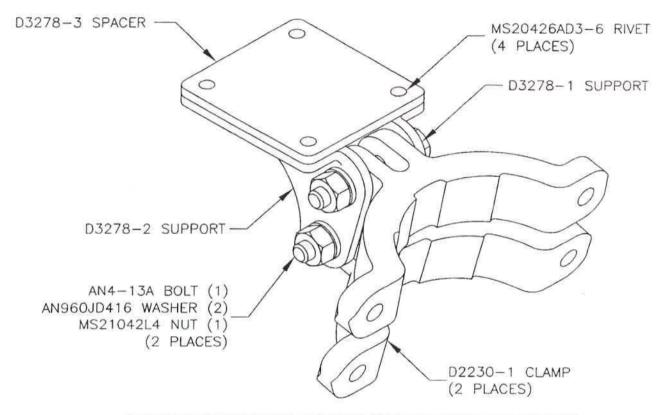
Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue P/O D3278-041	KJ/JLM	
В	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC X	E



DESIGN G.	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED A	DRAWING NO. R D3278 SHEET 1	EV. C
DATE 07.07.2	24	SUPPORT ASSEMBLY	SCALE
А	04.03.03	NEW ISSUE	
В	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
С	07.07.24	CHANGED RIVETS PER PAR #185	



### D3278-041 SUPPORT ASSEMBLY



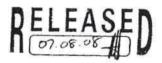
Qty	Part Number	Description	
X	D3278-041	SUPPORT ASSEMBLY	
2	D2230-1	CLAMP	
1	D3278-1	SUPPORT	UNC
1	D3278-2	SUPPORT	SIL
1	D3278-3	SPACER	
2	AN4-13A	BOLT	
4	AN960JD416	WASHER	
4	MS20426AD3-6	RIVET	
2	MS21042L4	NUT	

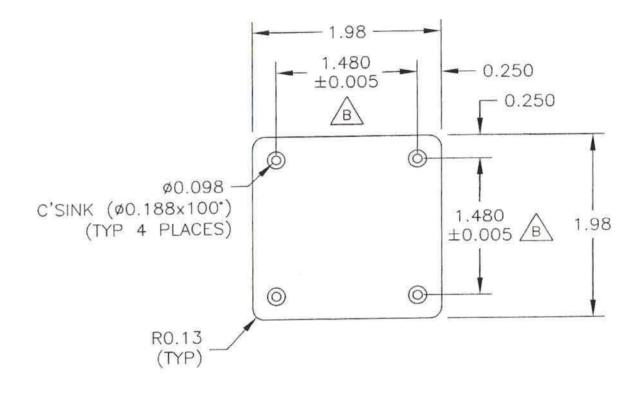
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DESIGN	DRAWN BY	DART AEROSF HAWKESBURY, ONTAI	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE	-44	D3278	SHEET 3 OF 3
07.07.24		SUPPORT ASSEMBLY	1:1





#### D3278-3 SPACER

1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)

- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP CONTRACTOR OF THE SUBJECT OF TH

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# Invoice

Γ	DATE	INVOICE NO.
	3/12/2008	17006

36 Colonnade Road N. Ottawa, Ontario K2E 7J6 Tel: (613) 226-1579

Fax: (613) 226-1719

BILL TO

Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7 SHIP TO

Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

					FOB
	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FI NOSS:
P.O. NO.		3/12/2008	Pick-Up	632	Globus
000005655	Net 30	3/12/2008	Tiek op		TATE OF THE PARTY.

QTY DESCRIPTION

145 D3278-2 B36811B Support

Business Number: 102122058

WHITE = Original BLUE = C of C YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum on Overdue Accounts



# Invoice

DATE	INVOICE NO.
3/12/2008	17006

<sup>3</sup>6 Colonnade Road N. Ottawa, Ontario K2E 7J6 Feb (613) 226-1579

Dart Aerospace 1270 Abordeen Street Hawksbury, Ontario			SHIP T	0	
			Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7		
P.O NO. TERMS SHIP DATE		SHIPPED VIA	JOB NO.	FOB	
000005655	Net 30	3/12/2008	Pick-Up	632	Globus
QTY		DESCRIPTION	L	RAT	E AMOUNT
		40			
				PSI	\$5:37 0.00
				CONTRACTOR OF THE	